

JIG DESIGN

which are very much alike, but that of Fig. 14 is simpler and more rapidly operated when the work is to be removed. When the clamp is slotted as shown in the plan view of Fig. 14, fixed studs may be used instead of the swinging bolts.

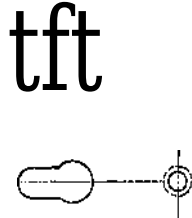


Fig. ii. Types of Clamping Straps

The type shown in Fig. 15 is often found in machine shops, on milling fixtures, drill jigs, lathe fixtures, etc. The clamp and bolts can be removed by loosening the nuts and pulling out the slip washers which allow the nuts to pass through the large

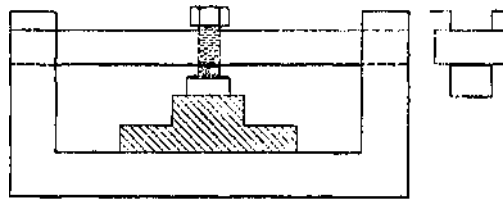


Fig. 12. Clamp Adapted to Box Jigs

holes. Fig. 16 illustrates a method which is commonly used on milling fixtures when light milling is to be done. The design of clamp shown in Fig. 17 is not frequently seen in use, as it is a method which a mechanic will not use if he can see another way out of it; but at times it is found almost impossible to use a clamp of a different type.